

Basecoat WB Three Stage System

Technical Bulletin

09/11/2019

L8.01.03 UK & Ireland

DESCRIPTION

A Basecoat WB three stage system consists of three separate applied layers creating a special color effect, based on:

- 1st step: Application of the solid or metallic Basecoat WB foundation color.
 - 2nd step: Application of the translucent, solid or pearl Basecoat WB effect color.
 - 3rd step: Application of the clearcoat to provide gloss and protection.
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COLOR CHECK

Correct color match needs to be done by producing a number of color spray-out samples, the color changes dependent on the number of coats applied of the effect color. Proceed as follows:

- Apply the foundation color until opacity is achieved on 5 different spray-out panels.
- Next apply one single coat of the effect color to all panels.
- Allow sufficient flash-off time and **remove one** panel before continuing this application process, resulting in spray-outs panels ranging with 1-5 coats of the effect coat.
- Allow for a 10-15 minutes flash-off time at 75°F (25°C) prior to clearcoat application.
- For optimum flash-off, dry the panels for several minutes in a oven or during a drying cycle in the spray booth.
- Apply two single layers of clearcoat to all color spray-out panels, securing brightness and color depth.

The operator can determine the right color match by using these color samples.

- Number each panel, indicating the number of effect coats on the panel.
 - Do not spray each panel separately.
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PREPARATION

The aim is to keep a repair as small as possible.

It is almost inevitable with three stage pearl application to use an additional body panel, required for color blend. This is mainly caused by the multiple layers to apply, ensuring OEM color match

Prior to preparation the decision has to be made on the number of panels (area required) to prepare.

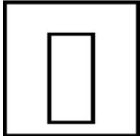
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BASECOAT WB FOUNDATION COLOR

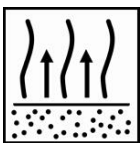


Ready For Use

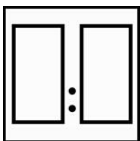


Apply 2 single coats to the primer area or until opacity is reached.

Extend the second coat over the edge of the previous coat.



Flash-off between coats by increasing airflow until completely matt.



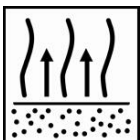
Blending foundation color:

Mix the ready to spray Basecoat WB foundation color 1:1 with the ready to spray effect color.



Apply one thin coat, gradually fading out this coat, facilitating a more uniform blend of the foundation color, and a smoother transition from the repair area to the original color.

In case of insufficient transparency add another 100 parts of ready to spray effect color into the Basecoat WB foundation ready to spray mixture, gradually fading out once more extending beyond the previous applied coat.



Allow for a minimum flash-off time of 15 minutes at 75°F (25°C).

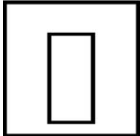
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BASECOAT WB EFFECT COLOR



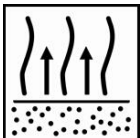
Ready For Use



Apply the first coat of the effect color as far as possible from the repair area, within the maximum panel area. Next apply the pre-determined sequential numbers of coats, keeping each layer within the previous applied coat. Start by applying a thin coat, as if fading in, then building up the layer thickness as one comes closer to the repair area.

Repeat this with each applied coat of the effect color.

- o Apply the number of required coats, dependent on the spray-out sample selection.
- o Do not lower the air pressure during application when applying the effect color.
- o Alternate the application with each layer of the effect color, do not overlap in the same area.
- o Application of the effect color must be executed similar as on the spray-out samples, ensuring similar layer thickness and color effect.
- o Apply the indicated number of layers of the effect color until an even color appearance is achieved.



Flash-off between coats by increasing airflow until completely matt.
Allow for a minimum of 20-30 minutes final flash-off time at 75°F (25°C).

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